

28

Date: Tuesday, 7/3/2007 2:43:18 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 33273  
 Estimate Number : 12520  
 P.O. Number : N/A Part Number : D205634045  
 This Issue : 7/3/2007 S.O. No. : N/A Drawing Number : D2580 REV C/DE09183B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C/B  
 Previous Run : 33272 Material : N/A  
 Due Date : 7/13/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.07.03  
 Comment : Est Rev. Revised Steps 06-09-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG001

N/A 07.07.03

2.0 D25001190



Comment: Qty.: 1.04000 Each(s)/Unit Total : 1.04000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion B29604

JB 7-7-3

3.0 D2596



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2596 205 Web B33058

JB 7-7-4

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends
- 3-Drill pilot holes using drill jig DT 8149
- 4-Acid etch and Alodine tube per QSI 005 4.1
- 5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

JB 7-7-3

JB 7-7-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M 104 732

Sikaflex expire date: 8-1-1

Start Time: 10:30 Date: 7-7-4

Fin Time: 7:00 Date: 7-7-5

JD 7-7-4

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-7-5

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using  
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using  
drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, \*\*\*DO NOT OPEN TO FINISH SIZE\*\*\*

5-Drill extra aft holes as per DEO 9183 using  
drill jig DT8463 locating from aft cap hole and aft saddle hole.

pm 07-07-05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SE 07-07-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D25763



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>B 29486</i>

*BE 07-07-06*

9.0

D2579



Comment: Qty.: 24.00000 Each(s)/Unit Total : 24.00000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	<i>B 32026</i>

*BE 07-07-06*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

*BE 07-07-06*

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*m104305*

*BE 07-07-06*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*m104305*

*BE 07-07-06*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*pmc/07-07-07*

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

*pmc/07-07-07*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

\*\*\*\*\*DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)\*\*\*\*

*pmc/07-07-07*

7-Open aft cap holes to #6 Drill bit. Deburr

*pmc/07-07-07*

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*pmc/07-07-07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Mar 07/09*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sw 07/09 (u)*

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat \*\*\*\*GREEN\*\*\*\*Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*Pressure wash  
M/8/44*

*FL 07/07/09 (u)*

*BR/FL 07-07-10*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*CR 7/7/10 (u)*

15.0

D25771



Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-1

Wearplate

*B31212*

16.0

D25773



Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-3

Wearplate

*B30551*

17.0

D25775



Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-5

Wearplate

*B31254*

*FL 07/07/10 (u)*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

ALS71032130



Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	m103618

19.0

AN960JD10L



Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	m103641

20.0

AN34A



Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	m104817

21.0

D25941



Comment: Qty.: 16.00000 Each(s)/Unit Total : 16.00000 Each(s)

plug

Batch:

B33446

22.0

D25943



Comment: Qty.: 16.00000 Each(s)/Unit Total : 16.00000 Each(s)

o-ring

Batch:

B27168

23.0

D2855



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Cap

Batch:

B33447

FL 07/07/10 ①

07.07.11②

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN35A



Comment: Qty.: 2.00000 Each(s)/Unit Total: 2.00000 Each(s)

Bolt

Batch: *m100188*

25.0

AN960JD10L



Comment: Qty.: 2.00000 Each(s)/Unit Total: 2.00000 Each(s)

Washer

Batch: *m103641*

*41 07-07-11 ①*

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 *m104636*

Sikaflex expire date: *07/09*

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg. D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 *m104636*

Sikaflex expire date: *07/09*

*} FZ 07/07/12 ①*

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

*m104733*

*FZ*

Batch: *07/07/12 ①*

27.0

QC5

INSPECT WORK TO CURRENT STEP



*All plugs are m the skid*

*Er 07/13*

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*PPP 32957 7/7/15*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date:   7/17/23  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33273

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16  
KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-07-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

98.08.28  
UP 08.08.28

EFFECTIVE DEOS  
98/12/08  
DEO 9124 # DED 9183

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33273

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

Diagram illustrating the grinding locations on a propeller cross-section. The diagram shows a cross-section of a propeller with various grinding points indicated by arrows and labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH
- GRIND FLUSH

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a bolt and nut assembly. The bolt is labeled "AN3-4A BOLT (1)" and the nut is labeled "AN960JD10L WASHER (1) (2 PLACES)". The bolt is shown passing through a hole in a plate, with a "D2575 CAP" (cover) indicated. The drawing includes a circular detail view of the bolt head and nut. Dimensions include a diameter of "Ø0.208" for the bolt head, a length of "0.40" for the bolt, and a note "DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)". A note "SEAL WITH SIKAFLEX-241" is also present. The drawing is labeled "UN" and "50" at the bottom.

Diagram of a wheel assembly showing components and inspection points:


- 02579 SPACER
- 02596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 44 PLACES)
- AFTER PERFORM
- 1. CHA
- 2. INS
- 3. WEL
- 4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

[illegible]

RELEASE  
98/09/17 DS

DESIGN <i>DH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED <i>DH</i>	APPROVED <i>JS</i>	
DATE 98.08.26	TITLE 205 SKIDTUBE ASSEMBLY	REV. C SHEET 2 OF 2 SCALE 1:24







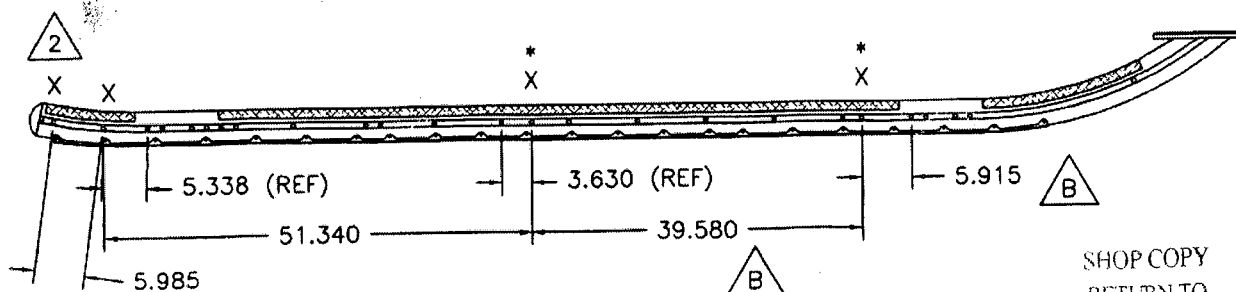
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DEO 9183	REV. B SHEET 1 OF 1
DATE 00.05.15		TITLE ADD SKIDTUBE P/N D2580-045	SCALE NTS
A	00.03.29	NEW ISSUE	
B	00.05.15	39.580 WAS 39.620	

## DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
  - a) DRILL  $\varnothing 0.508$  HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES  $0.030 \times 45^\circ$ . NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE \* LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO  $\varnothing 0.63$  AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
  - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
  - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
  - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION  $\varnothing 0.380$ - $\varnothing 0.390$ .
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33273

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9184	REV. A SHEET 1 OF 1
DATE 00.03.29		TITLE ADD SKIDTUBE P/N D205-634-015	SCALE NTS
A	00.03.29	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88  
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL  
TO PARTS LIST FOR D205-634-011 EXCEPT THAT:  
D205-634-045 REPLACES D205-634-041  
D2580-045 REPLACES D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041)  
AND D205-634-015 (D205-634-045) IS THAT EXTRA  
SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND  
ASSEMBLY IS PAINTED GREEN.

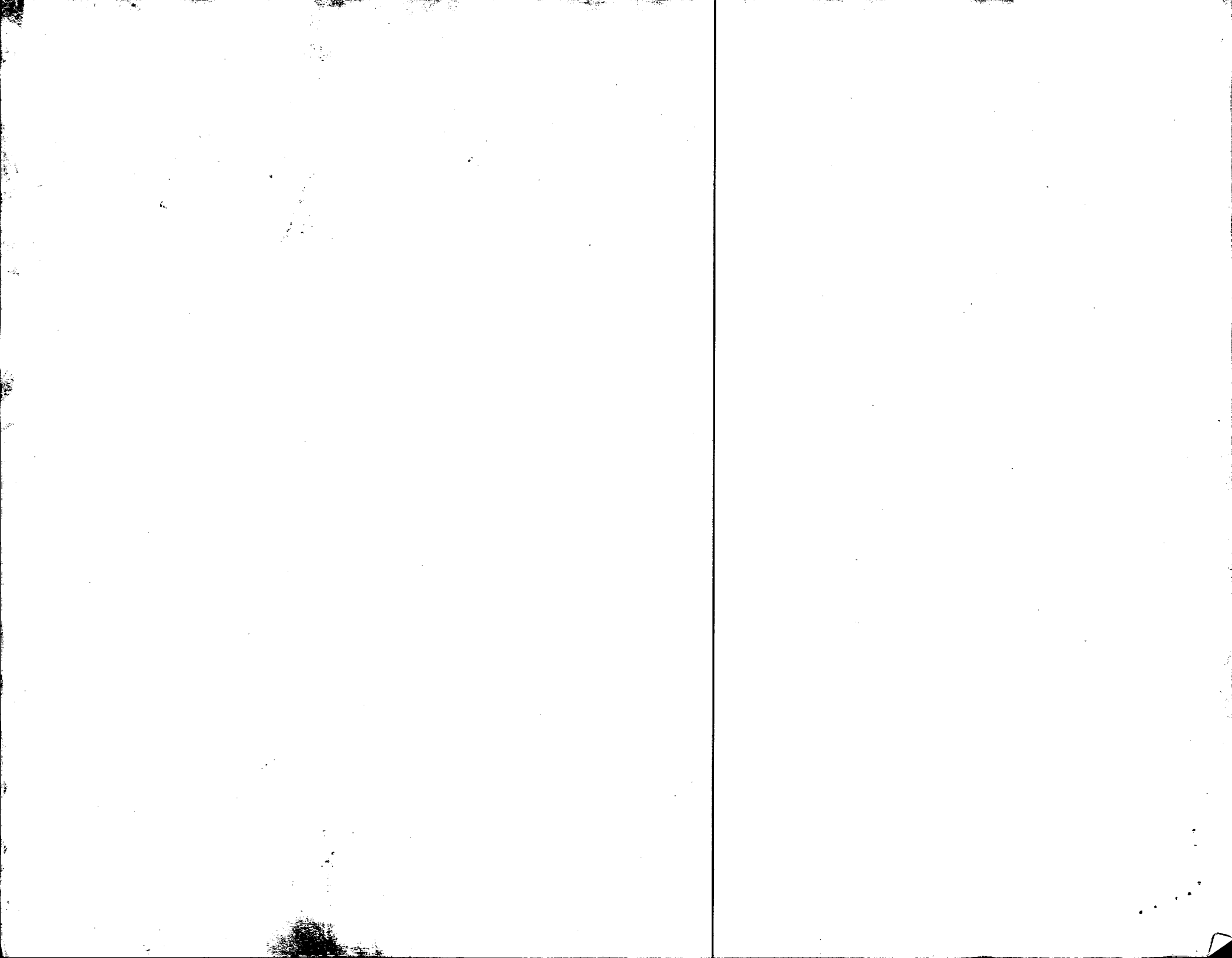


D205-634-015 (D205-634-045)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33273

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



NO. 115

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D285634045 / 638273

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/09 Qualifier David Lavel